Work Ord June-24-13 1:5		3552		*103	3552*							Page 1
Item ID: Revision ID: Item Name:	D3245-2 Panel			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	6/24/13 : 7/05/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
Approvals:		•	Date: 13-06-26	Tooling: _ SPC (Y/N):		ate:		;		Start Stop		R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr					,	,				
D3245	D											
*100 *100* Waterjet		FLOW WATER JET Memo		0.00				6	(ಲ.		A. 13.07.1
FLOW CNC Water, 304.032	rjet	Dwg Rev:_ Prog Rev:_	D	3245-1/-2****								•
*110		2-Deburr if QC2- Inspect parts off n		0.00				_6_		٠	^ -	Ae '
OC		Memo		0.00								13.07

Quality Control

DQA:			Date:											"DAPT
OA Clasadi			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	147	ork Order up	ndata anlu - [AEROSPACE
QA Closed:			Date:		1	···	_			VV	ork Order up	date only		<u> </u>
Work Orde	er:					DISPOSITION			AGAINST	r DE	PARTMENT	/PROCESS		
			<u>.</u>		_	Rework	1		Skid-tube Crosstube]	Water Jet		Engineering
Part N	۱o.					Scrap			Machining Small Fat		Pro	d. Eng. Coor.	_	Quality
						Use-as-is			moforming Finishing	3	4	re/Packaging		Other
NCR N	No					Suspected Unapproved			Large Fab Composite]	Supplier		
Root		I			Descr	iption of work order update		nitial	Action	-	Sign &		-	
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling			1			;								
Handling/Pre														#
Material	Щ													
Operator		ŀ												
Offset/Setup														
Process														
Supplier		İ												
Training														·
Transport														
Unapproved														
							FAI	ULT CAT	TEGORY		<u> </u>			
Landii	ng Gear					General				_	1	r		•
		ding				Bend		•	Program	<u> </u>	Outside Dim	ŀ		Pressure/Forced
	Cen	itre Not	Concen	itric	<u> </u>	BOM/Route		Grain		<u> </u>	Over/Under	· · · · · · · · · · · · · · · · · · ·		Set-up
	Cra				igspace	Broken/Damage/Defect		Hardwa		\perp	Part Incorred			Temperature/Cure
		• -	(/Ripple,	/Wave	<u> </u>	Burrs		i i	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing		Weld
	Cuff					Contamination		4	tions Incomplete/Unclear	<u> </u>	Part Moved			Wrong Stock Pulled
		shing				Countersink	_	1	gned/off center	<u></u>	Positioned V			
	\blacksquare	t Treat				Cut Too Short		Mislabe			Power Loss/	Surge		Other
			Strip in	Tube		Drawing		Misread						<u> </u>
	-	rks/Cha				Drill Holes	$oxed{oxed}$	Off-set						
		•	quence		<u> </u>	Finish		i	Calibration '					
	l lW∍	ve/Twis	t in Tuh	6		Fit/Function		Out of 9	Sanuanca					

Work Orde June-24-13 1:58		3552		*103	3552*							Page 2
Revision ID:	D3245-2 Panel			Accept	*N900	<u>040</u>	100)* ፡	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date: Reference:	6/24/13 7/05/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:	ID:						
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:	-]		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 120 *120 CQC Quality Control	•	Operation Description QC8- Inspect parts - second Memo	and check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC		NC BRAKE Memo 1- C'sink as	per Dwg D3245	0.00								Bi
		2- Form D32	245-1 as per Dwg D3245					6				13/

3- DEBURR

Identify as D3245-1

DQA:			Date:										"DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		/ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
Work Orde	er: _					(,				· ¬		
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No					Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No					Suspected Unapproved]		Large Fab	Composite	_	Supplier	<u>ا</u> ا
Root	•				Desc	ription of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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Equip/Tooling	Ш												
Handling/Pre							1						
Material	Щ							ς,	- -				
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Process	Ш												
Supplier	Щ												
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Unapproved			1										<u></u>
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Landi					_	General	_			_	_	_	
	Ш	Bending				Bend	<u> </u>	ŧ .	rogram,	_	Outside Dim	⊢	Pressure/Forced
	Ш	Centre No	ot Concer	ntric		BOM/Route	$ldsymbol{ld}}}}}}$	Grain			Over/Under	-	Set-up
		Cracks				Broken/Damage/Defect	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Hardwa		_	Part Incorred	j 	Temperature/Cure
	Ш	Crimp/Kir	nk/Ripple	/Wave		Burrs	ldash	1	ion Incomplete/Ur	· —	Part Lost/Mi	ssing	Weld
	Ш	Cuffs				Contamination	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	4	ions Incomplete/l	Jnclear	Part Moved	-	Wrong Stock Pulled
	Ш	Crushing				Countersink		Misalig	ned/off center	L	Positioned V		_
	-	Heat Trea			<u> </u>	Cut Too Short	_	Mislabe	eled	L	Power Loss/	Surge	Other
	Ш	Inspection	n Strip in	Tube		Drawing		Misread	.				
		Marks/Ch	atter			Drill Holes		Off-set					
	Ш	Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function	[Out of	Sequence				

Work Ord June-24-13 1:5		03552		*10:	3552*			Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3245-2 Panel 6/24/13: 7/05/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N9000401 Cust Item ID: Customer:		Setup Start Stop	*NS2*
Approvals:	Process P	an:	Date:	Tooling:	Date:		Run Start	*NR1*
	QC:		Date:	_ SPC (Y/N):	Date:		Stop	*NR2*
Sequence ID/ Work Center I 140 *140* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours 0.00 SV 0.00 13. 8	~\f7	Plan Accept Code Qty		Reject Insp. Number Stamp
*150 *150* Packaging Packaging		Identify as per dwg & Sto	ock Location: <u>ST23</u> .	3 0.00		<u>6x</u>	1 _ M.	V. 13-08-19
*160 *160* QC Quality Control		QC21- Final Inspection - Memo	- Work Order Release	0.00		····· ›	<u>5 3-</u>	08-21

DQA:		- Date:			. WORK ORDER NON	~	SNEO	DRAARICE / LI	D A T C			TOART
QA Closed:		Date:			WORK ORDER NON-	-((JINFU	RIVIAINCE / UI		Work Order uj	odate only	AEROSPACE
Mark Orda					DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	
Work Orde					Rework	ı		Skid-tube	Crosstube	\neg	Water Jet	Engineering
Part N	lo				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
10(1)					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	lo.				Suspected Unapproved			Large Fab	Composite		Supplier	
Root			ļ	Desci	ription of work order update	ı	nitial	Act		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design												'
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Offset/Setup	_	1				l						
Process												
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						FA	JLI CA	TEGORY				
Landir	ng Gear				General		 		г			70
-	Bending	ot Conce		\vdash	Bend BOM/Route			Program		Outside Dim	├	Pressure/Forced
ł	Cracks	ot Concei	ntric	-	Broken/Damage/Defect	<u> </u>	Grain			Over/Under		Set-up
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	Cuffs	iik/kiphie	y wave	├-	Burrs Contamination			ion Incomplete/Un	- F	Part Lost/Mi Part Moved	SSING	Weld
ŀ	Crushing				Countersink	-		tions Incomplete/U	inclear	 	L.	Wrong Stock Pulled
ŀ	Heat Trea			\vdash	Cut Too Short	\vdash	Mislabe	gned/off center	}	Positioned V Power Loss/		Other
ŀ	Inspectio		Tubo	-	Drawing		Misread		L	rower Loss/	onike [Other
ŀ	Marks/Cl	-	Tube	-	Drill Holes	\vdash	Off-set					
ŀ	Turning S				Finish	\vdash		Calibration				
ŀ	Wave/Tv	•		-	Fit/Function	\vdash		Seguence			<u></u>	

June-24-13 1:58:07 PM

Work Order ID:

103552

Parent Item:

D3245-2

Parent Item Name:

Panel

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A04.07.07New issueKJ/JLM

IPP Rev:b ECN 1052 07-10-31 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	: Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	171.9800	0.804	5.0778948	£		
304/316 .032 Sheet				<u>Location</u>		Loc Oty	Lo	c Code			13	, 07,	15
				MAT020		171.98							
				118	3271	10.76							
					0866 1889	55.47 105.75			-	1			1

DQA:			Date:				_						*DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD/		ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er: <u>-</u>					Down rk 🗍	1		Skid tuba	racetuha	1	Water Jet	Engineering
Dart N	No.					Rework Scrap			—	Crosstube Small Fab	Dro	d. Eng. Coor.	Quality
Part N	NO	· ·				Use-as-is			⊸——	Finishing		re/Packaging	Other
NCR I	VΩ					Suspected Unapproved	i	THETH	~H	omposite	1 1100/3101	Supplier	-
110111	•••						J		za ge raz oc				
Root					Desc	ription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description	on	Date	Verification	QC Inspector
Design		·						· <u>-</u> -				- -	
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Equip/Tooling													
Handling/Pre	Щ												
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Operator	Ш												
Offset/Setup	Ш												14
Process	Ш												
Supplier	Ш												
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Unapproved	Ш		<u> </u>	<u> </u>	<u> </u>		<u> </u>					·	<u> </u>
						· · · · · · · · · · · · · · · · · · ·	FA	ULT CAT	regory			<u> </u>	
Landi						General	_	1			7	<u></u>	-
	${}$	Bending			-	Bend	<u> </u>	-{	rogram	<u> </u>	Outside Dim	-	Pressure/Forced
-		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			Over/Under		Set-up
		Cracks		•		Broken/Damage/Defect	╙	Hardwa			Part Incorred	ļ	Temperature/Cure
	⊢⊣	Crimp/Kii	nk/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	╣ ′	ion Incomplete/Unqua	, _	Part Lost/Mi	ssing	Weld
	\vdash	Cuffs				Contamination	<u> </u>	4	ions Incomplete/Uncle	ear	Part Moved	L	Wrong Stock Pulled
	-	Crushing			-	Countersink	⊢	-	ned/off center	<u> </u>	Positioned V		٦٠٠٠
	\vdash	Heat Trea			\vdash	Cut Too Short	<u> </u>	Mislabe		<u></u>	Power Loss/	Surge	Other
l:	\vdash	Inspectio	•	Tube		Drawing	<u> </u>	Misread	1				
	-	Marks/Ch				Drill Holes	\vdash	Off-set	~ 111 · ·				
	⊢	Turning S Wave/Tw			\vdash	Finish Fit/Function	 - -	4	Calibration Sequence			·	· · · · · · · · · · · · · · · · · · ·
i	, ,	M11997671	asian int)P	ı	TERM EURICHON	1	י זמ זוונטו	Sealence				

DART AEROSPACE LTD	Work Order: \03557	
Description: Panel	Part Number: D3245-2	
Inspection Dwg: D3245 Rev: D	Page 1 of	1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098	_		V	UKm-01
Ø0.375	+0.006/-0.001	0,376	-		V	
0.400	+/-0.010	,400	-		V	
1.117	+/-0.010	1,117	_		v	
1.150	+/-0.010	1.150	_		V	
1.000	+/-0.005	1.000	_		٧	
10.57	+/-0.030	10.57	.		T	UKM-06
9.500	+/-0.010	9,500	1		7	
8.350	+/-0.010	8,350	-			
3.500	+/-0.010	3.500	1		T	
9.40	+/-0.030	9.40	•		T	
11.04	+/-0.030	11.04	_		T	
6.200	+/-0.010	6.200	_		T	
2.230	+/-0.010	2.23			V	
2.020	+/-0.010					
			يىن			

Measured by: Audited by: Preliminary Approval:

Date: 13.07.15

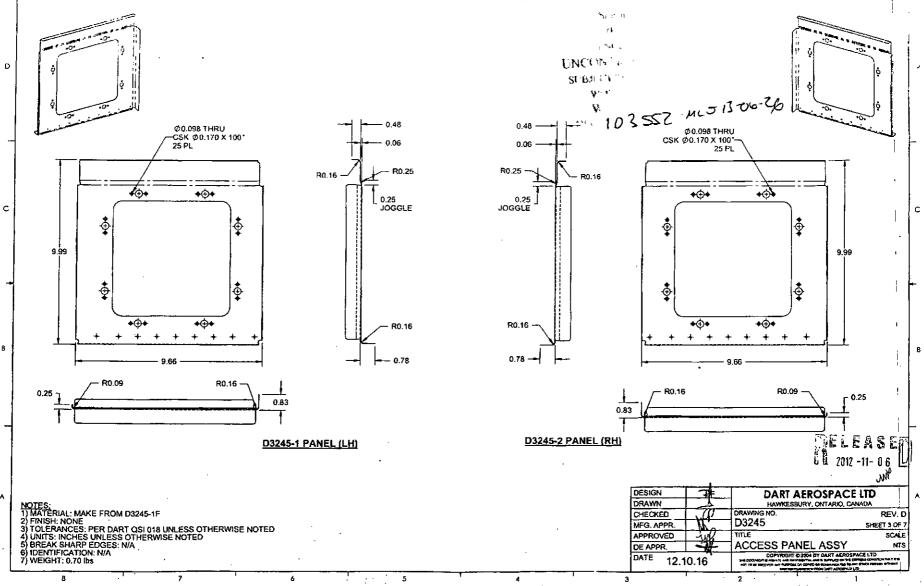
Date: 13.7-/5

Date: 13.07.15

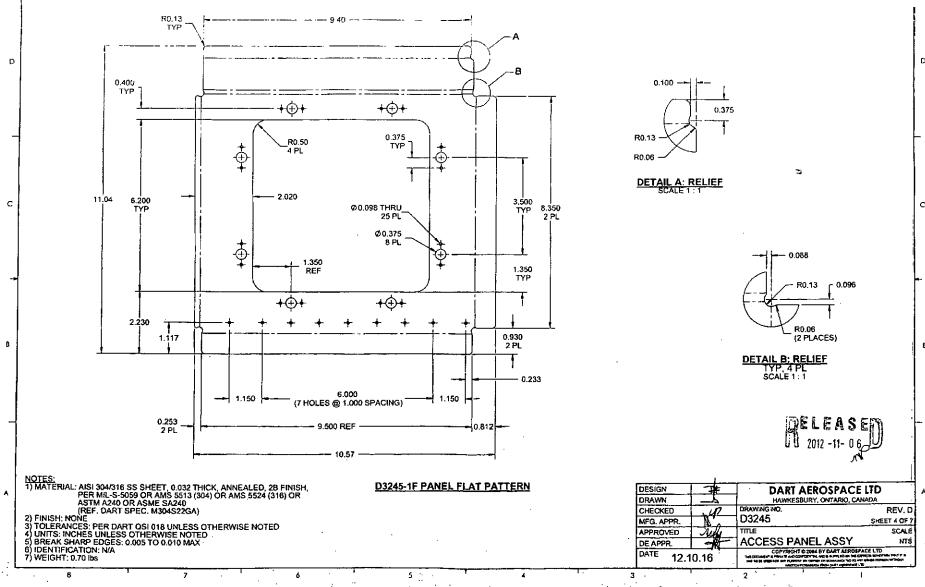
Rev	Date	Change	Revised by	Approved
Α	08.09.04	New Issue	KJ/DD	,
В	12.05.14	Dimensions updated per Dwg Rev C	KJ 众	
С	13.02.27	Dwg Rev updated	KJ 🎝	40
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